



US009184334B2

(12) **United States Patent**  
**Hsia et al.**

(10) **Patent No.:** **US 9,184,334 B2**  
(45) **Date of Patent:** **Nov. 10, 2015**

(54) **LED STRUCTURE**

(71) Applicant: **TSMC Solid State Lighting Ltd.**,  
Hsinchu (TW)

(72) Inventors: **Shouli Steve Hsia**, San Jose, CA (US);  
**Chih-Kuang Yu**, Chiayi (TW); **Ken**  
**Wen-Chien Fu**, Hsinchu (TW);  
**Hung-Yi Kuo**, Taipei (TW);  
**Hung-Chao Kao**, Taipei (TW);  
**Ming-Feng Wu**, Toufen Township (TW);  
**Fu-Chih Yang**, Fengshan (TW)

(73) Assignee: **TSMC Solid State Lighting Ltd.**,  
Hsinchu (TW)

(\*) Notice: Subject to any disclaimer, the term of this  
patent is extended or adjusted under 35  
U.S.C. 154(b) by 0 days.

(21) Appl. No.: **14/451,508**

(22) Filed: **Aug. 5, 2014**

(65) **Prior Publication Data**

US 2014/0339579 A1 Nov. 20, 2014

**Related U.S. Application Data**

(60) Division of application No. 14/082,663, filed on Nov.  
18, 2013, now Pat. No. 8,809,899, which is a  
continuation of application No. 13/167,878, filed on  
Jun. 24, 2011, now Pat. No. 8,587,018.

(51) **Int. Cl.**

**H01L 33/00** (2010.01)

**H01L 27/15** (2006.01)

**H01L 33/62** (2010.01)

(52) **U.S. Cl.**

CPC ..... **H01L 33/0008** (2013.01); **H01L 27/15**  
(2013.01); **H01L 33/005** (2013.01); **H01L**  
**33/62** (2013.01); **H01L 33/0004** (2013.01)

(58) **Field of Classification Search**

CPC ..... H01L 2224/48091; H01L 2924/00014;  
H01L 2924/00; H01L 2224/73265; H01L  
2924/01322; H01L 25/0753; H01L  
2224/32225; H01L 2224/16225; H01L  
2924/13091; H01L 33/486; H01L 33/60;  
H01L 2224/48227

See application file for complete search history.

(56) **References Cited**

**U.S. PATENT DOCUMENTS**

7,122,901 B2 10/2006 Sunohara et al.  
2008/0169548 A1 7/2008 Baek et al.  
2010/0102735 A1 4/2010 Chang et al.

**OTHER PUBLICATIONS**

Kevin Tseng, "Protection Zener Series a New Application in LED  
Field" Powered by Nature, Jul. 7, 2004, pp. 1-14.

*Primary Examiner* — Robert Bachner

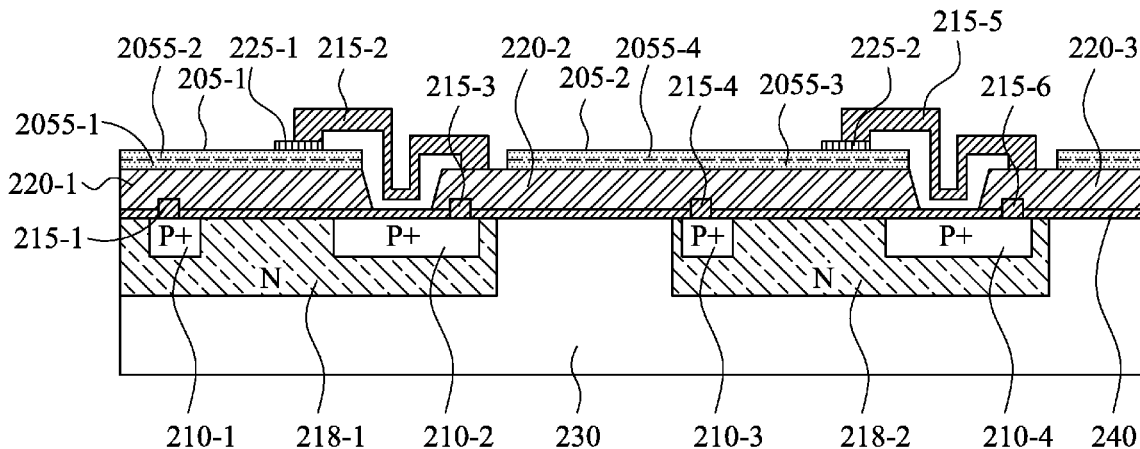
(74) *Attorney, Agent, or Firm* — Muncy, Geissler, Olds &  
Lowe, P.C.

(57)

**ABSTRACT**

A light emitting diode (LED) structure comprises a first  
dopant region, a dielectric layer on top of the first dopant  
region, a bond pad layer on top of a first portion the dielectric  
layer, and an LED layer having a first LED region and a  
second LED region. The bond pad layer is electrically con-  
nected to the first dopant region. The first LED region is  
electrically connected to the bond pad layer.

**20 Claims, 16 Drawing Sheets**



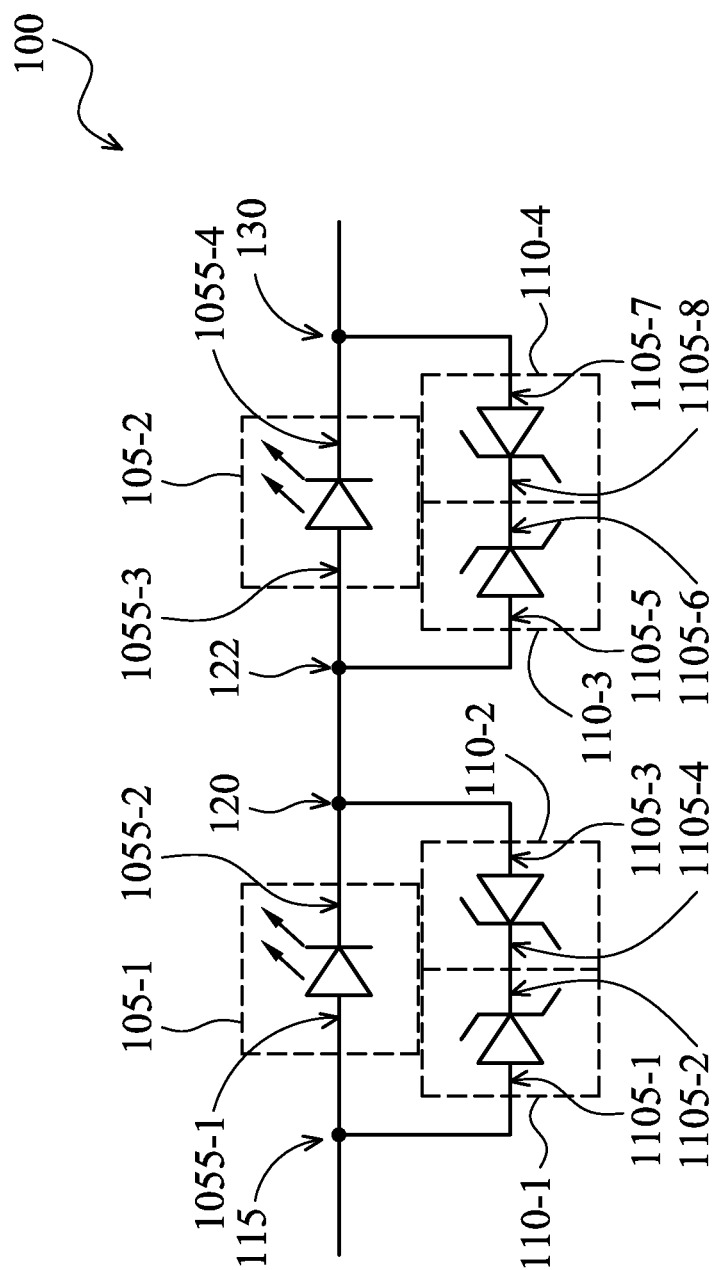


Fig. 1

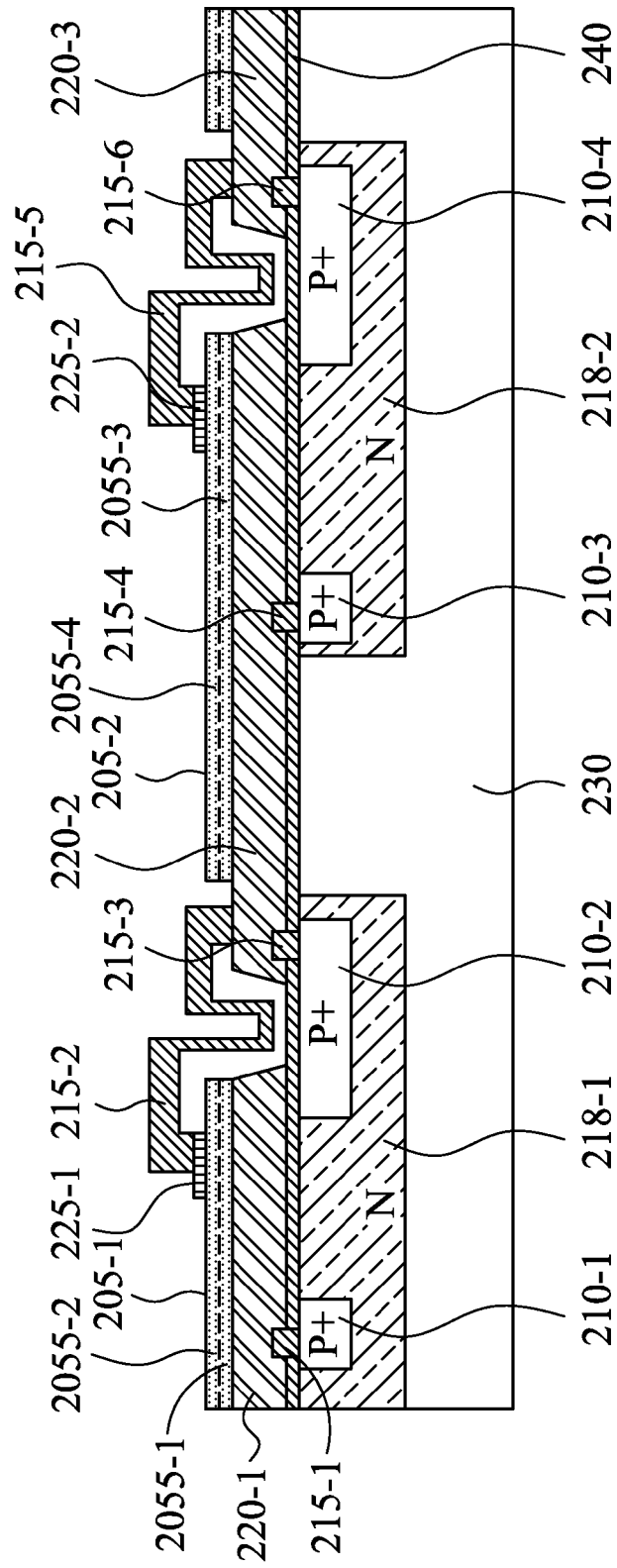


Fig. 2

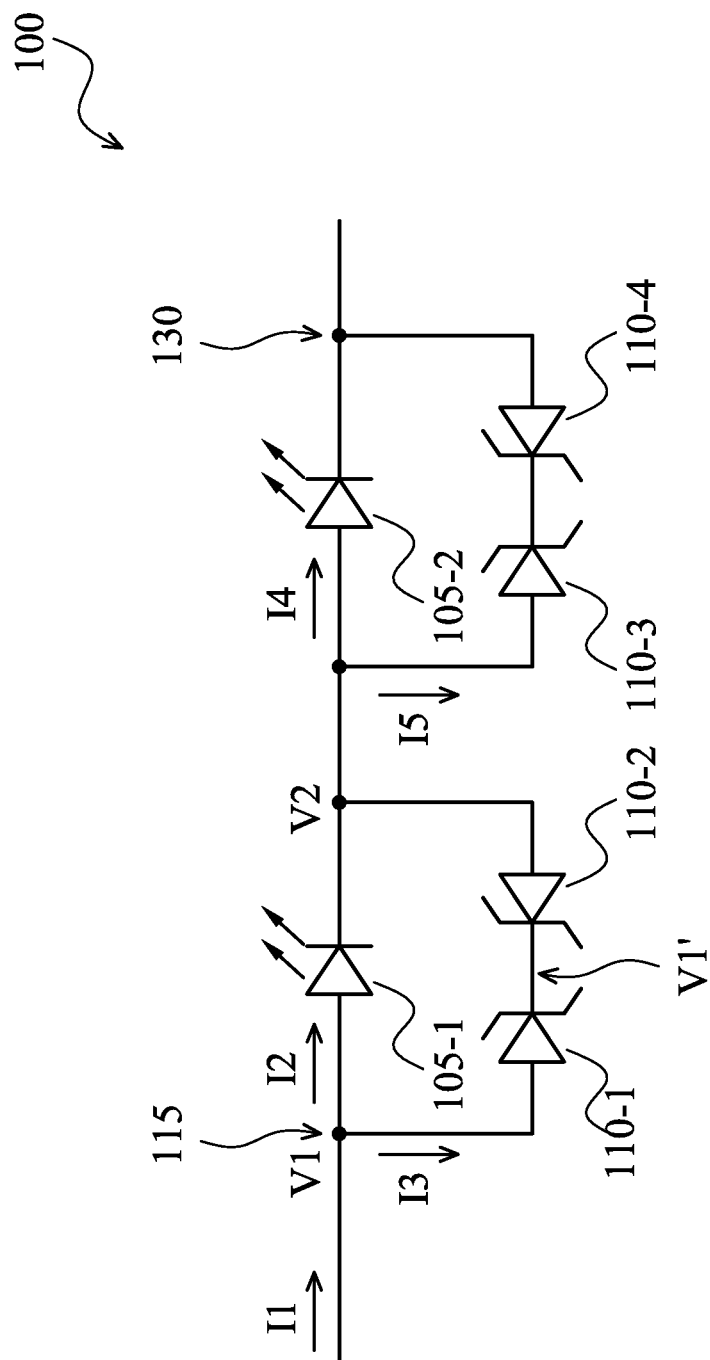


Fig. 3

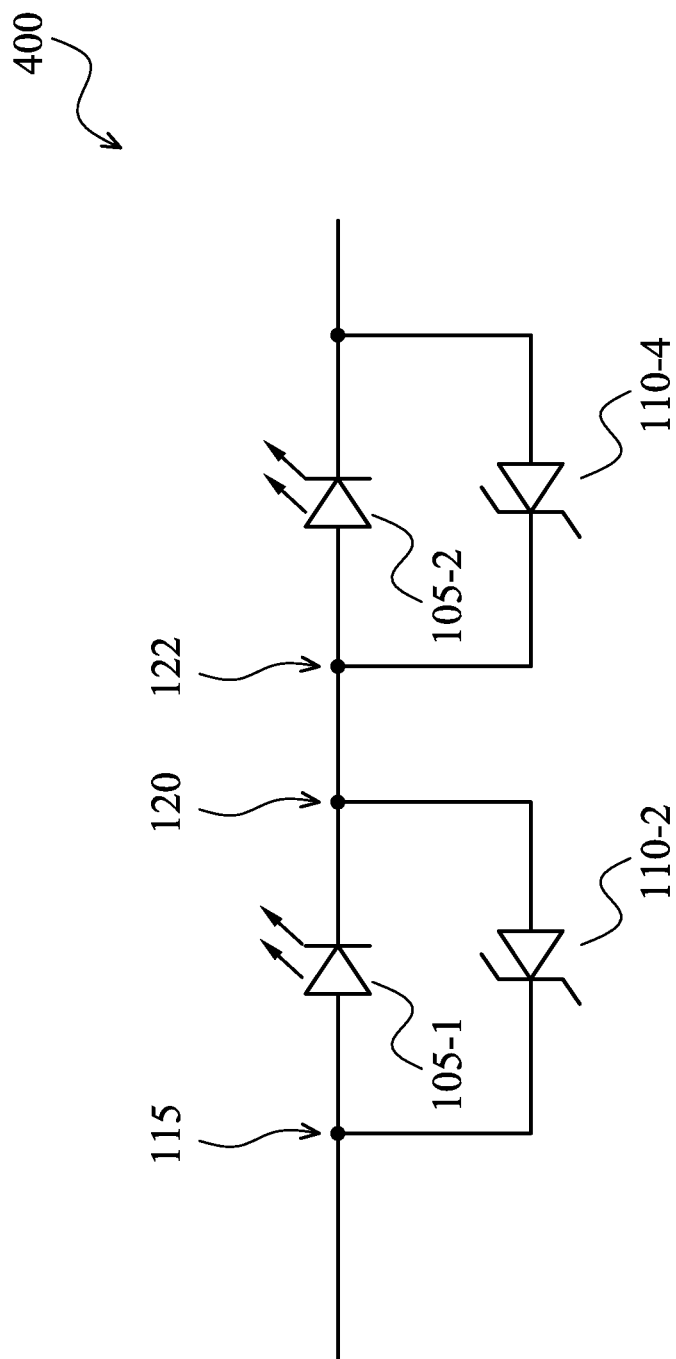


Fig. 4

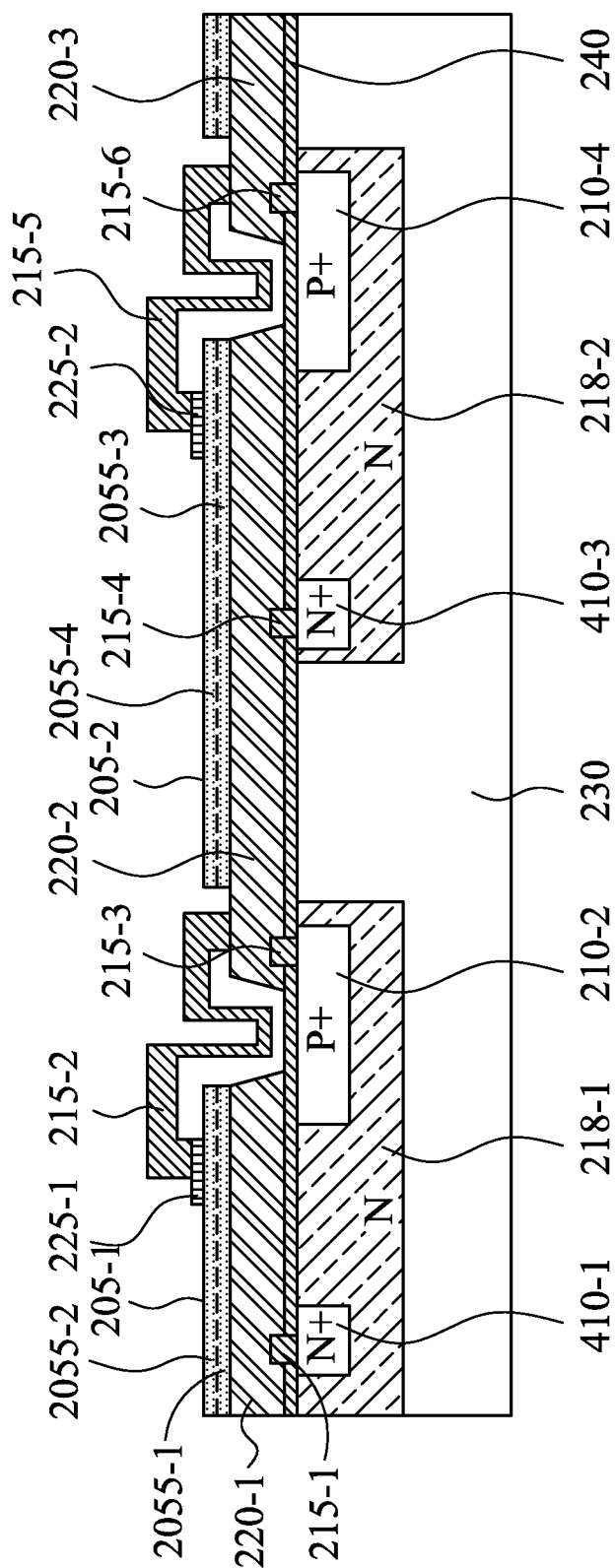


Fig. 5

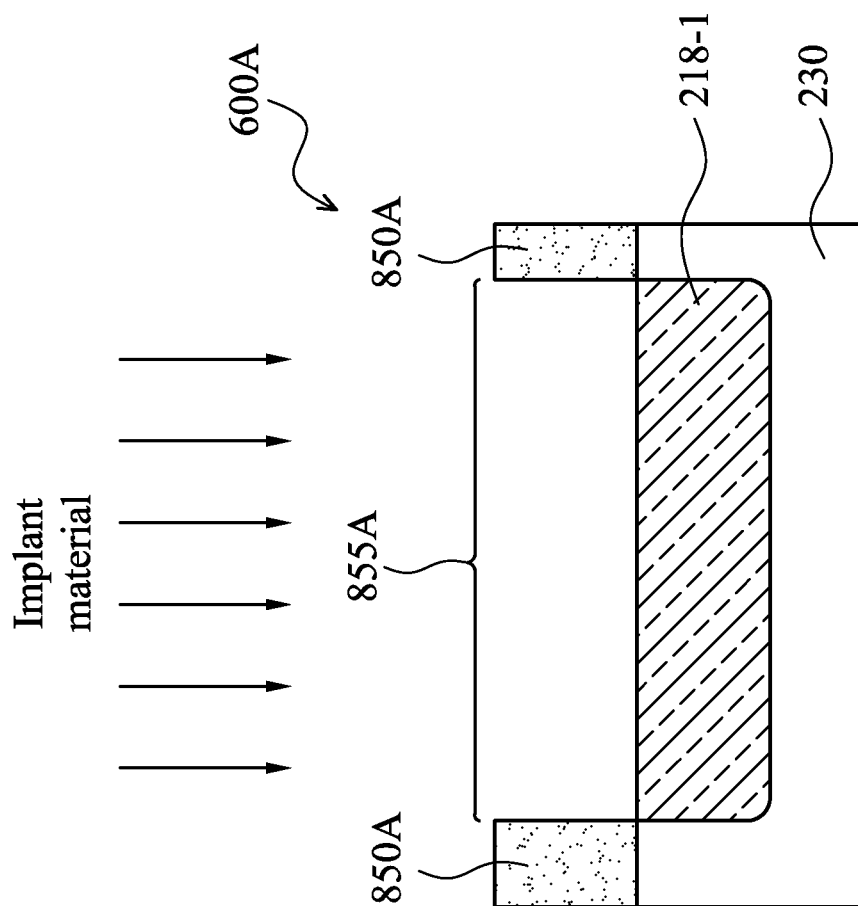


Fig. 6A

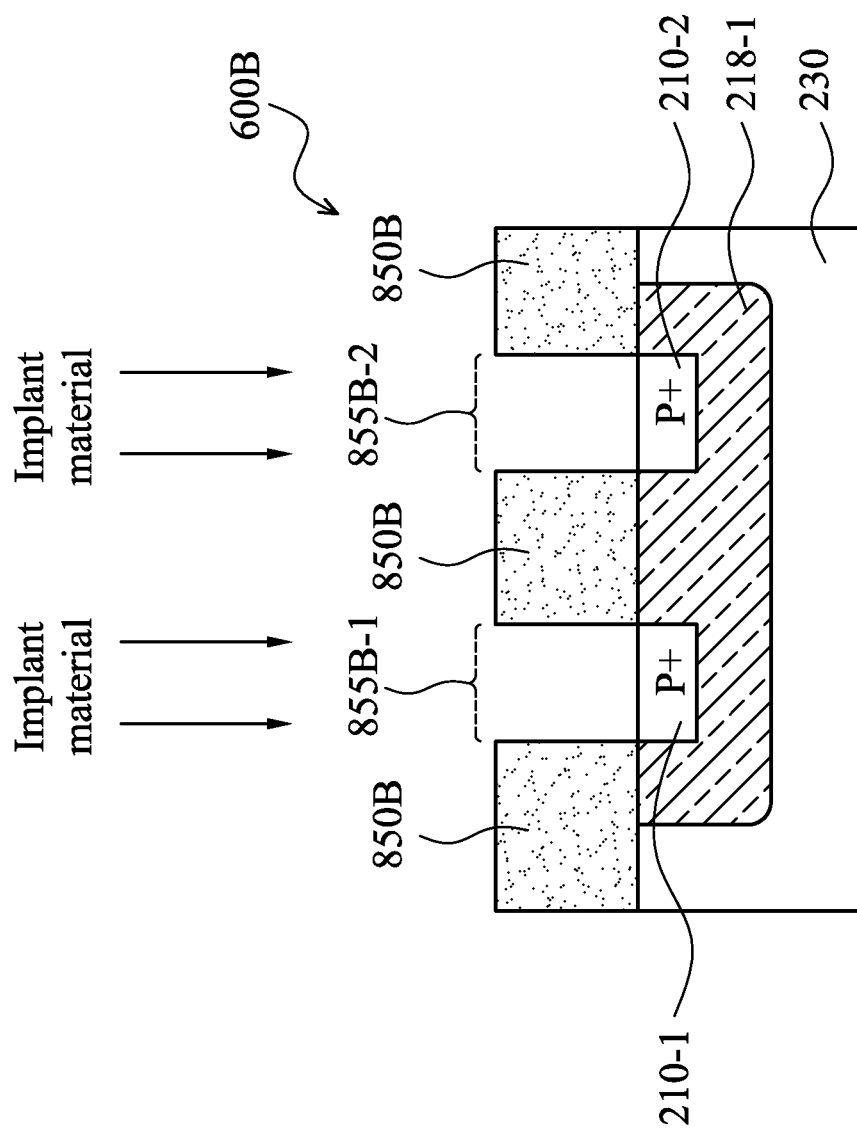


Fig. 6B



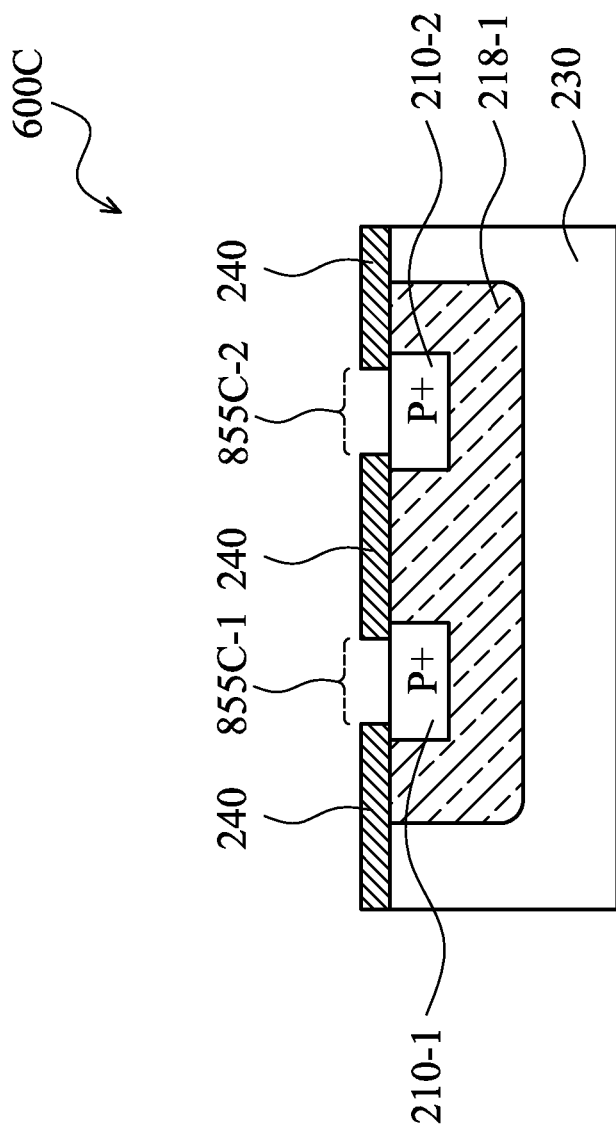


Fig. 6C

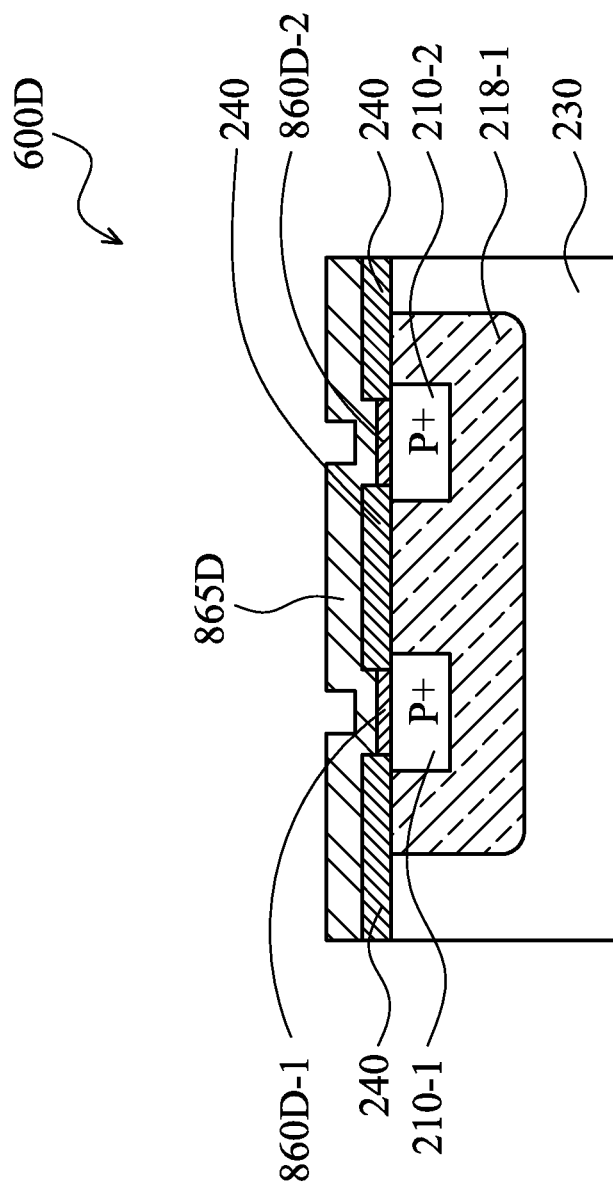


Fig. 6D

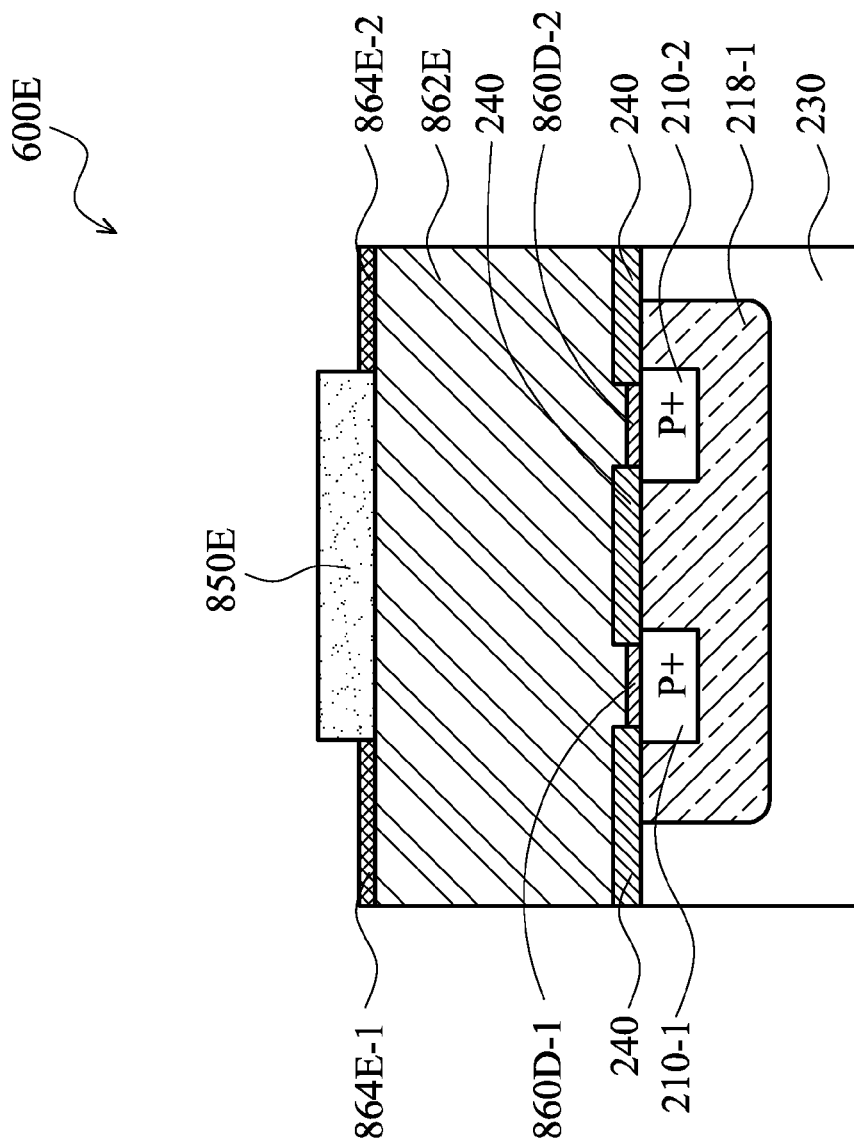


Fig. 6E

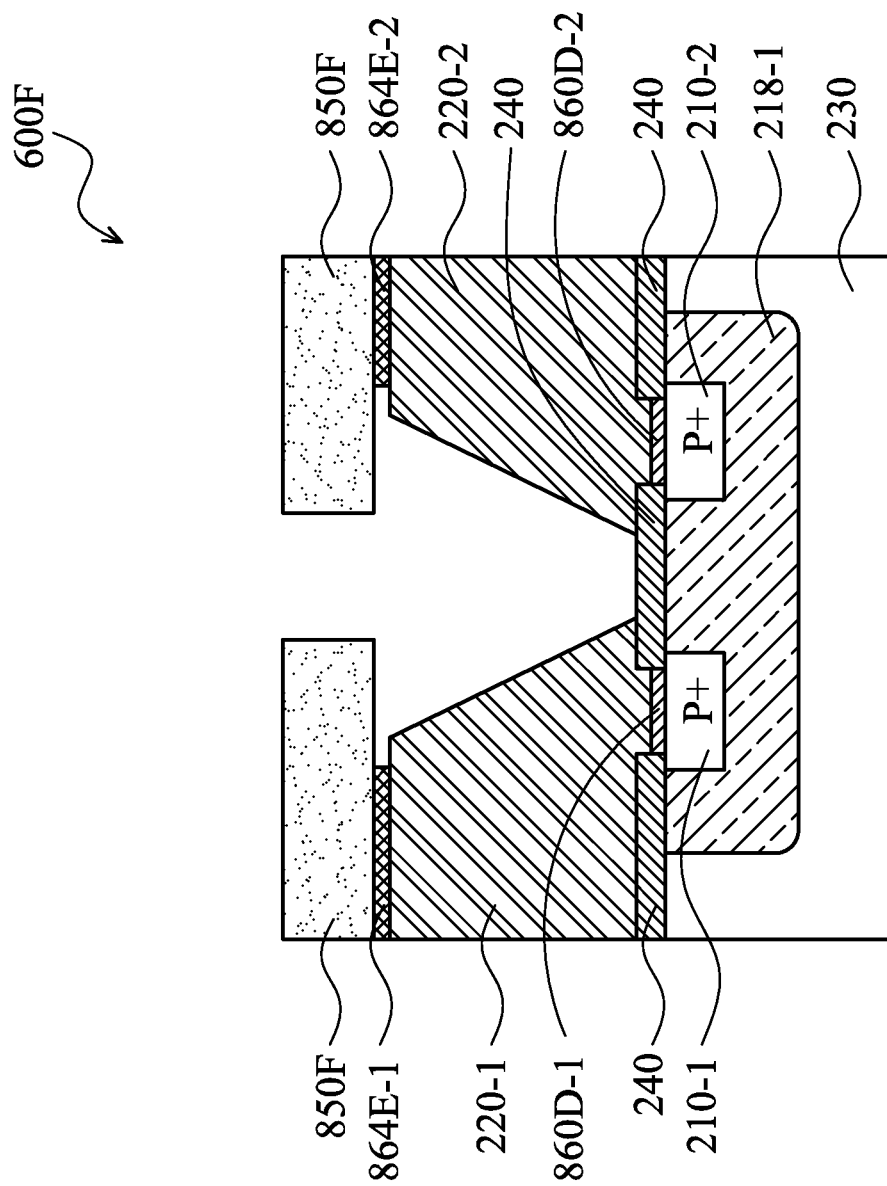


Fig. 6F

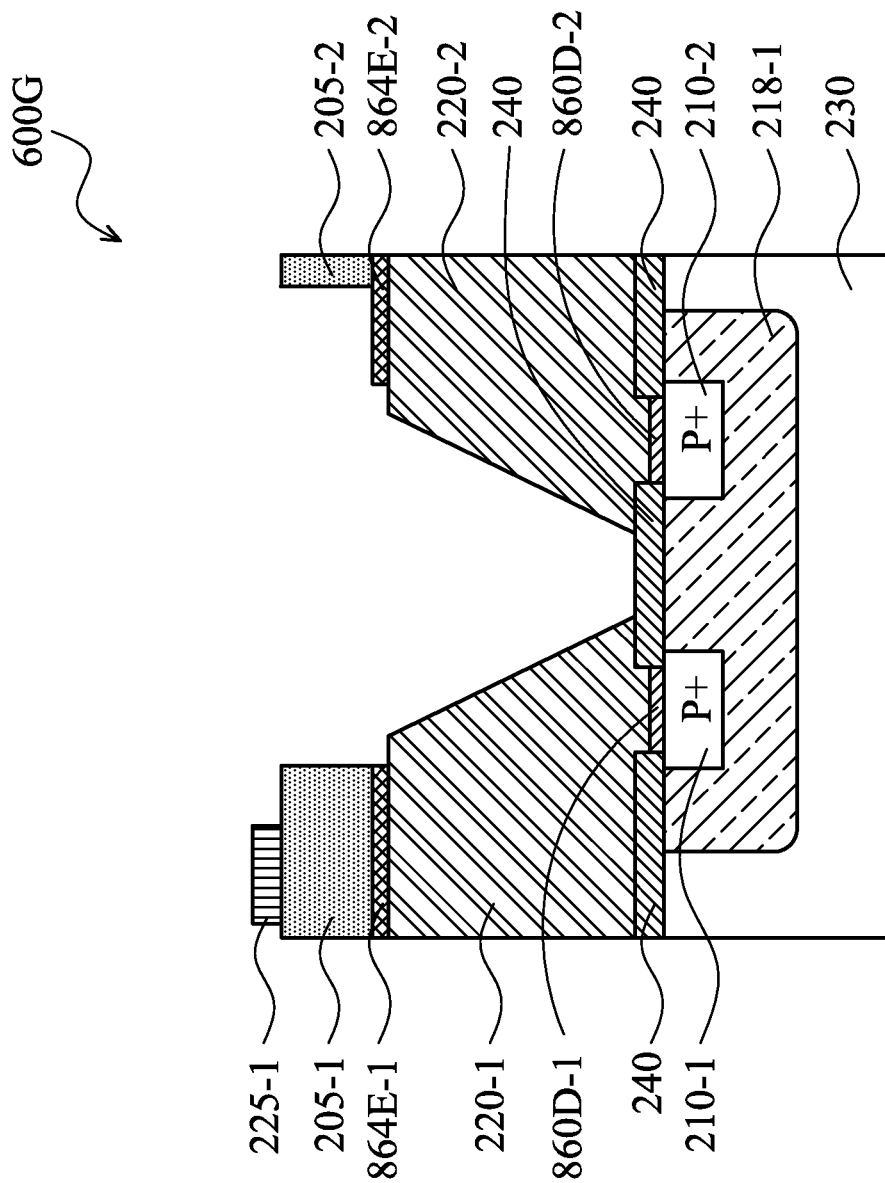


Fig. 6G

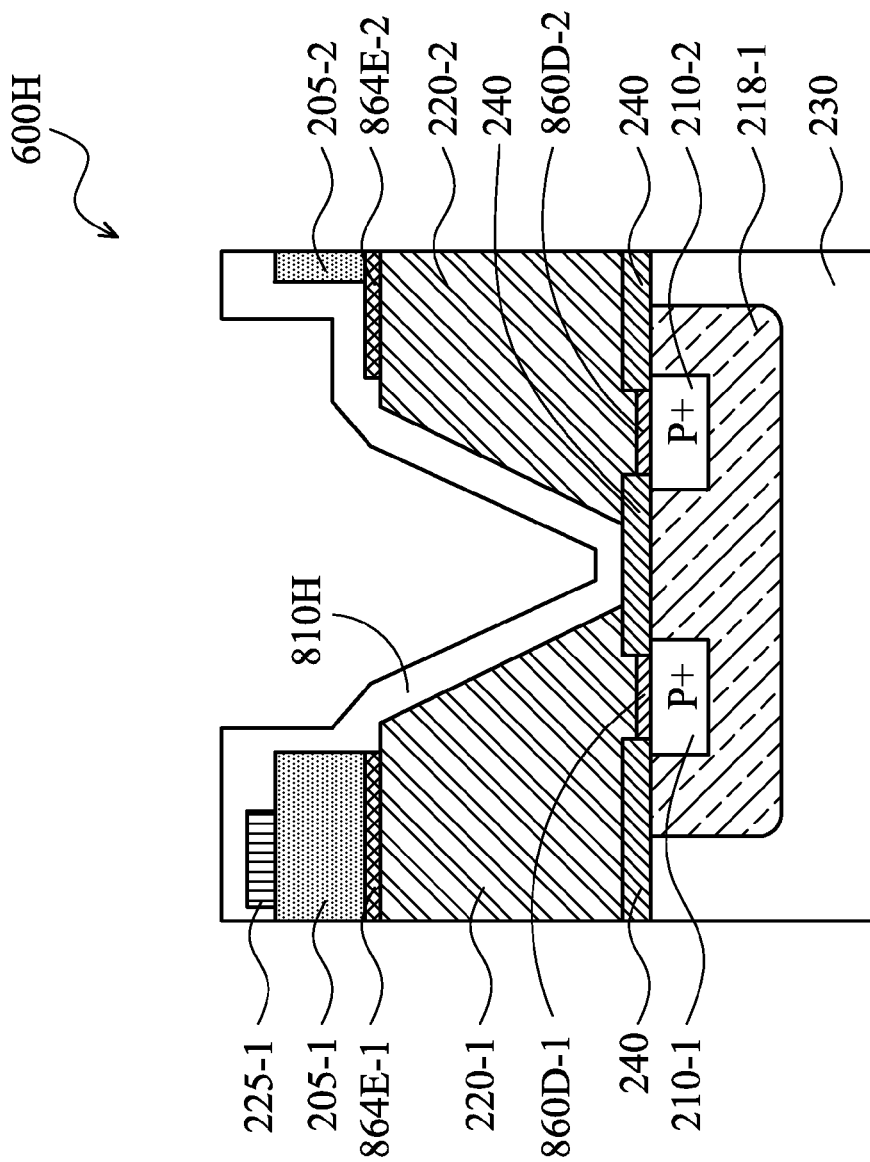


Fig. 6H

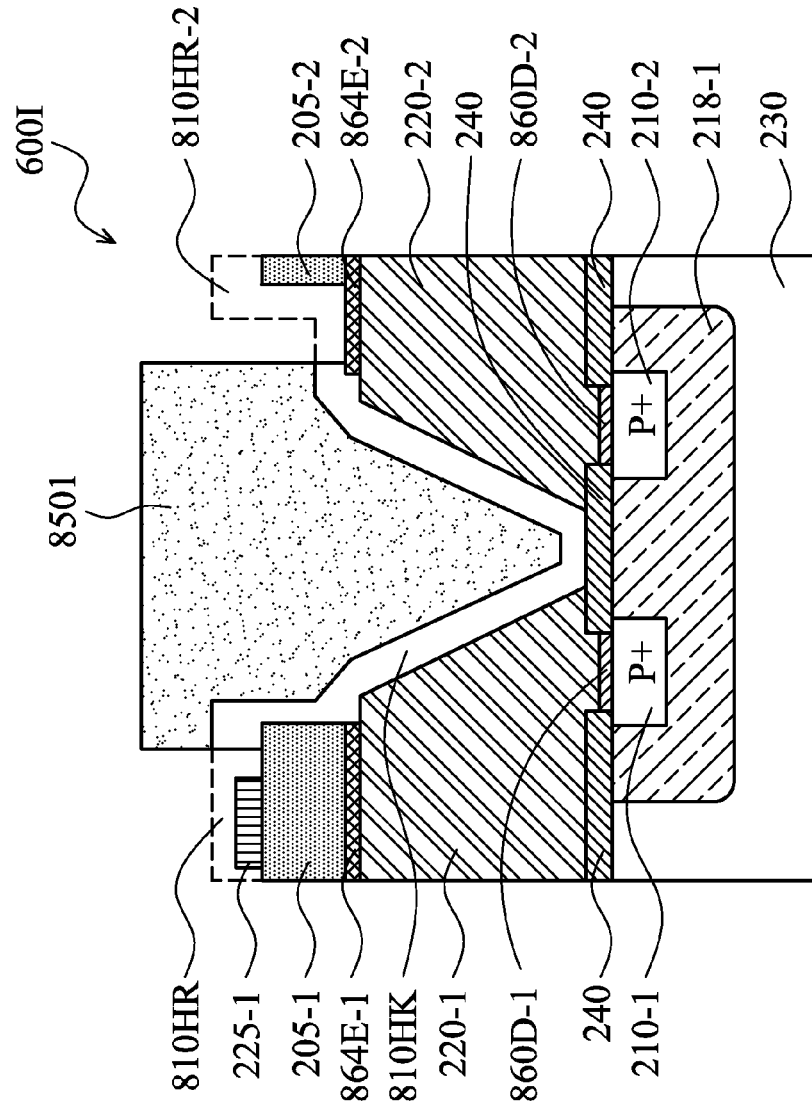


Fig. 6I

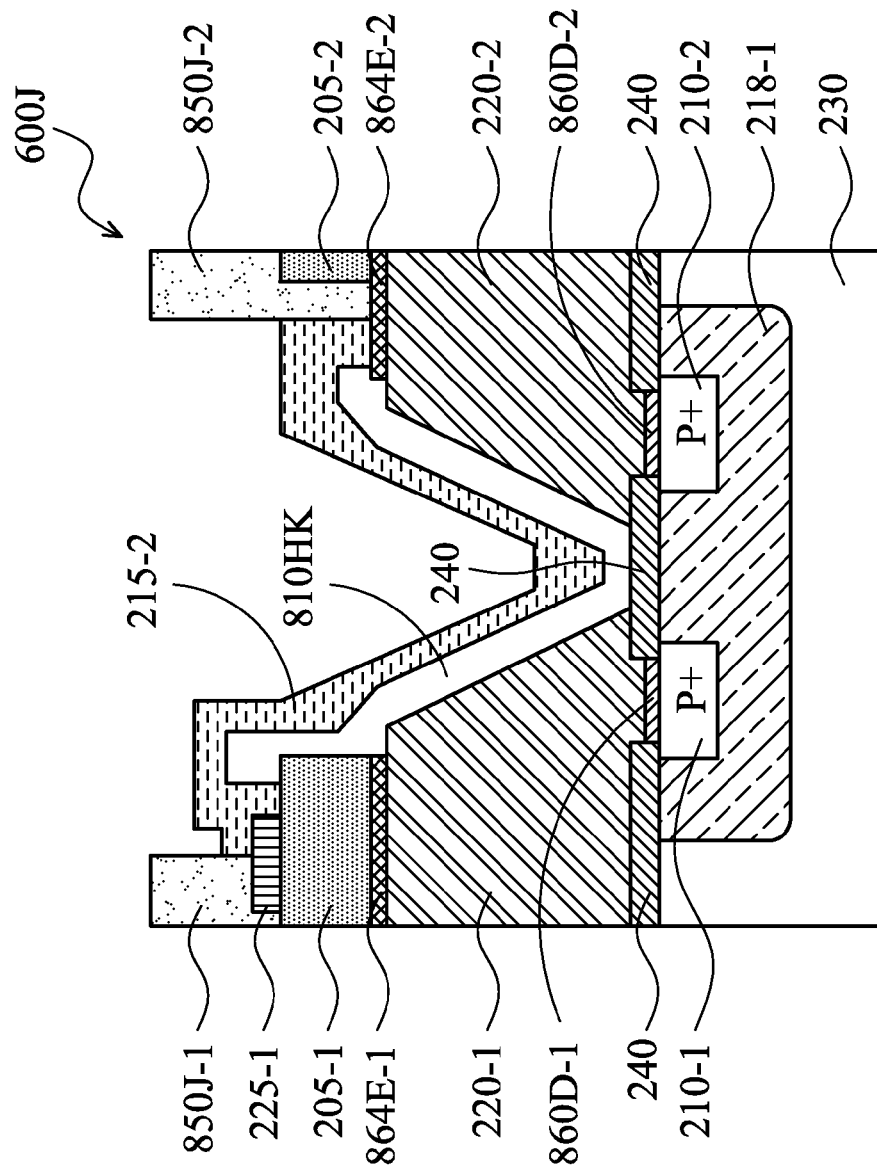


Fig. 6J



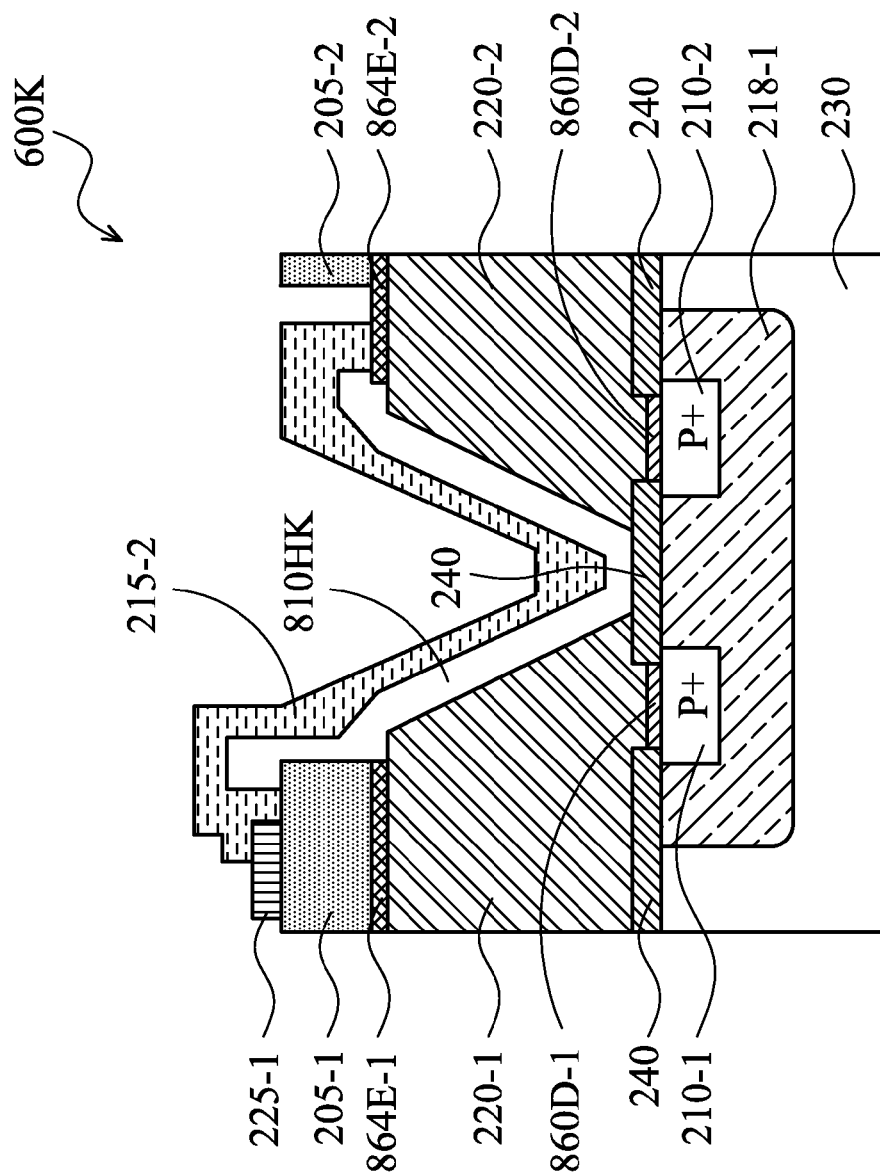


Fig. 6K

# 1

## LED STRUCTURE

### PRIORITY DATA

The present application is a divisional patent application of U.S. patent application Ser. No. 14/082,663, filed on Nov. 18, 2013, now U.S. Pat. No. 8,809,899, issued Aug. 19, 2014, which is a continuation patent application of U.S. patent application Ser. No. 13/167,878, filed on Jun. 24, 2011, now U.S. Pat. No. 8,587,018, issued Nov. 19, 2013, the disclosures of each are hereby incorporated by reference in their entirety.

### FIELD

The present disclosure is related to a light emitting diode (LED) structure.

### BACKGROUND

In some approaches, high voltage light emitting diode (LED) solutions include discrete LEDs and Zener diodes mounted on a print circuit board (PCB). The whole circuitry, however, occupies PCB space. Integrating the LEDs and the Zener diodes on the PCB also poses challenges.

In some other approaches, a high voltage multi P-N junction LED die is used. Here, the Zener diodes are mounted with the LED die on a board. The Zener diodes, however, protect the die and/or the package chip, but do not protect the P-N junctions on the die. During fabrication of the LED or assembly of the circuit with the LEDs, the junctions and thus the LED die may be damaged due to an electro static discharge (ESD). Additionally, because the LEDs operate under a high voltage, the junctions may also be damaged due to the high break down voltage.

### BRIEF DESCRIPTION OF THE DRAWINGS

The details of one or more embodiments of the disclosure are set forth in the accompanying drawings and the description below. Other features and advantages will be apparent from the description, drawings, and claims.

FIG. 1 is a diagram of an LED circuit and FIG. 2 is a cross section view of a semiconductor structure represented by the LED circuit in FIG. 1, in accordance with a first embodiment.

FIG. 3 is a diagram of the LED circuit in FIG. 1 with various details not labeled, in accordance with some embodiments.

FIG. 4 is a diagram of an LED circuit and FIG. 5 is a cross section view of a semiconductor structure represented by the LED circuit in FIG. 4, in accordance with another embodiment.

FIGS. 6A-6K are cross section views illustrating the steps of manufacturing the LED circuit in FIG. 1, in accordance with some embodiments.

Like reference symbols in the various drawings indicate like elements.

### DETAILED DESCRIPTION

Embodiments, or examples, illustrated in the drawings are disclosed below using specific language. It will nevertheless be understood that the embodiments and examples are not intended to be limiting. Any alterations and modifications in the disclosed embodiments, and any further applications of the principles disclosed in this document are contemplated as would normally occur to one of ordinary skill in the pertinent art. Reference numbers may be repeated throughout the

# 2

embodiments, but they do not require that feature(s) of one embodiment apply to another embodiment, even if they share the same reference number.

Some embodiments have one or a combination of the following features and/or advantages. Various embodiments are used in a high or ultra high voltage multi junction LED die and/or packages. For example, the voltage ranges from 130 V to 260 V. The voltage is a direct current (DC) or an alternating current (AC). The Zener diodes are embedded in the silicon substrate. The embedded Zener diodes prevent breakdown of the silicon substrate and the passivation layer. The Zener diodes also protect the multi-junctions. The LEDs circuit and the protection circuits are manufactured in a same die, are processed at the wafer level, and are integrated in a fabrication process. cl Exemplary Circuit

FIG. 1 is a diagram of an LED circuit 100 and FIG. 2 is a cross section diagram of a semiconductor structure represented by the LED circuit 100, in accordance with some embodiments. For simplicity, various elements in the cross section view are not shown in the circuit view. In this document, “P” and “N” refer to the P dopant and N dopant, respectively. Further, an N dopant type refers to an N dopant having a lightly doped concentration (N-), a regularly doped concentration (N), or a heavily doped concentration (N+). Similarly, a P dopant type refers to a P dopant having a lightly doped concentration (P-), a regularly doped concentration (P), or a heavily doped (P+) concentration.

Circuit 100 having two LEDs 105-1 and 105-2 is used for illustration. A chain of LEDs 105 having different numbers of LEDs is within the scope of various embodiments. The operation of the LED chain having more than two LEDs should be recognizable by persons of ordinary skill in the art in view of the illustrative embodiments disclosed in this document. In some embodiments, the LED chain includes 80 LEDs and 80 corresponding protection circuits.

LED 105-1 includes a P side 1055-1 and an N side 1055-2. LED 105-1 corresponds to LED layer 205-1 in FIG. 2, and is lit when a voltage applied across LED 105-1 is higher than the threshold voltage of LED 105-1. At that time, a current flows through LED 105-1. In some embodiments, the threshold voltage of LED 105-1 is about 3.2 V. The P side 1055-1 of LED 105-1 corresponds to the bottom portion 2055-1 of LED layer 205-1. The N side 1055-2 of LED 105-1 corresponds to the top portion 2055-2 of LED layer-1 205-1. In some embodiments, LED 105-1 is epitaxially grown with corresponding dopants. For example, the P portion is epitaxially grown with a P dopant, and the N portion is epitaxially grown with an N dopant.

In some embodiments, an LED 105 is coupled to a pair of Zener diodes 110. For example, LED 105-1 is coupled to a pair of Zener diodes 110-1 and 110-2. The P side 1105-1 of Zener diode 110-1 is coupled to the P side 1055-1 of LED 105-1. The P side 1105-3 of Zener diode 110-2 is coupled to the N side 1055-2 of LED 105-1. The N sides 1105-2 and 1105-4 of Zener diodes 110-1 and 110-2 are coupled together. Zener diode 110-1 is formed by P+ region 210-1 (i.e., a heavily P-doped region) and N region 218-1 illustratively shown in FIG. 2. P side 1105-1 of Zener diode 110-1 corresponds to P+ region 210-1. N side 1105-2 of Zener diode 110-1 corresponds to N region 218-1. Zener diode 110-2 is formed by P+ region 210-2 and N region 218-1. P side 1105-3 of Zener diode 110-2 corresponds to P+ region 210-2. N side 1105-4 of Zener diode 110-2 corresponds to N region 218-1. Zener diodes 110-1 and 110-2 are formed in a P-type silicon substrate 230. A silicon substrate is commonly called a silicon carrier or a silicon submount. Zener diodes 110 are called

embedded Zeners because they are embedded in substrate 230. Zener diodes 110 serve as protection circuits for LEDs 105.

Connecting metal 215-1 in the form of a via connects P+ region 210-1 and bond pad 220-1. In some embodiments, bond pad 220-1 includes metal. Bond pad 220-1 is in contact and electrically coupled with portion 2055-1 of LED layer 205-1. As a result, portion 2055-1 is electrically coupled with P+ region 210-1. This coupling corresponds to the circuit representation in FIG. 1 that P side 1055-1 of LED 105-1 is coupled to P side 1105-1 of Zener diode 110-1 through node 115.

Connecting metal 225-1 couples portion 2055-2 of LED layer 205-1 and connecting metal 215-2. Bond pad 220-2 couples connecting metal 215-2 and via 215-3. Because via 215-3 is coupled to P+ region 210-2, P+ region 210-2 is electrically coupled to N region 2055-2 of LED layer 205-1. This coupling corresponds to the circuit representation that P side 1105-3 of Zener diode 110-2 is coupled to N side 1055-2 of Zener diode 105-1 through node 120.

Similar to LED 105-1, LED 105-2 includes a P side 1055-3 and an N side 1055-4. LED 105-2 corresponds to LED layer 205-2 in FIG. 2, and is lit when a voltage applied across LED 105-2 is higher than the threshold voltage of LED 105-1. At that time, a current flows through LED 105-2. In some embodiments, the threshold voltage of LED 105-2 is about 3.2V. The P side 1055-3 of LED 105-2 corresponds to the bottom portion 2055-3 of LED layer 205-2. The N side 1055-4 of LED 105-2 corresponds to the top portion 2055-4 of LED layer 205-2.

Similar to LED 105-1 being coupled to a pair of Zener diodes 110-1 and 110-2, LED 105-2 is coupled to a pair of Zener diodes 110-3 and 110-4. The P side 1105-5 of Zener diode 110-3 is coupled to the P side 1055-3 of LED 105-2. The P side 1105-7 of Zener diode 110-4 is coupled to the N side 1055-4 of LED 105-2 via node 130. The N sides 1105-6 and 1105-8 of respective Zener diodes 110-3 and 110-4 are coupled together. Zener diode 110-3 is formed by P+ region 210-3 and N region 218-2. P side 1105-5 of Zener diode 110-3 corresponds to P+ region 210-3. N side 1105-6 of Zener diode 110-3 corresponds to N region 218-2. Zener diode 110-4 is formed by P+ region 210-4 and N region 218-2. P side 1105-7 of Zener diode 110-4 corresponds to P+ region 210-4. N side 1105-8 of Zener diode 110-4 corresponds to N region 218-2. Similar to Zener diodes 110-1 and 110-2, Zener diodes 110-3 and 110-4 are formed in the P-type silicon substrate 230.

Via 215-4 connects P+ region 210-3 and bond pad 220-2. Bond pad 220-2 is in contact and electrically coupled with portion 2055-3 of LED layer 205-2. As a result, portion 2055-3 of LED layer 205-2 is electrically coupled with P+ region 210-3. This coupling corresponds to the circuit representation in FIG. 1 that P side 1055-3 of LED 105-2 is coupled to P side 1105-5 of Zener diode 110-3 through node 122.

Connecting metal 225-2 couples portion 2055-4 of LED layer 205-2 and connecting metal 215-5. Bond pad 220-3 couples connecting metal 215-5 and via 215-6, which is coupled to P+ region 210-4. As a result, P+ region 210-4 is electrically coupled to N portion 2055-4 of LED layer 205-2. This coupling corresponds to the circuit representation that P side 1105-7 of Zener diode 110-4 is coupled to N side 1055-4 of Zener diode 105-2 through node 130.

Node 120 is electrically the same as node 122, both of which couple N side 1055-2 of LED 105-1, P side 1055-3 of LED 105-2, P side 1105-3 of Zener diode 110-2, and P side 1055-5 of Zener diode 110-3 together. This coupling corresponds to the fact that N portion 2055-2 of LED layer 205-1, connecting metal 215-2, bond pad 220-2, connecting metal

215-3, P+ region 210-2, P portion 2055-3 of LED layer 205-2, via 215-4, and P+ region 210-3 are electrically coupled together.

Passivation layer 240 is a non conducting layer, used to electrically separate conducting layers. For example, layer 240 electrically separates N region 218-1, P+ region 210-1, P+ region 210-2, N region 218-2, P+ region 210-3, and P+ region 210-4 from bond pads 220-1, 220-2, and 220-3. Layer 240 also electrically separates LED layer 205-1 from connecting metal 215-2, etc. In some embodiments, passivation layer includes silicon oxide. Further, various embodiments are advantageous over other approaches because Zener diodes 110 prevent the breakdown of its silicon-carrier and passivation layer 240.

In some embodiments, when an LED 105 in an LED chain does not function, the rest of the LEDs in the chain continue to function, i.e., continues to produce light. Various embodiments are therefore advantageous over other approaches in which when an LED in an LED chain does not function, the rest of the LEDs in the chain are not lit.

#### Exemplary Operation of Circuit 100

FIG. 3 is the same circuit diagram of the LED circuit 100, but without various details of LEDs 105-1, 105-2, and Zener diodes 110-1, 110-2, 110-3, and 110-4. For illustration, voltage V1 is sufficient to light all LEDs 105 in the chain of LEDs 105. For example, if an LED 105 takes 3.0 V to operate, voltage V1 of 300 V is used to light a chain of 100 LEDs 105.

For illustration of one operational state, the conditions present when LEDs 105-1 and 105-2 function normally will be described. In some embodiments, the threshold voltage of an LED 105 is about 3.0V, while the threshold voltage of a Zener diode 110 is about 7.0 V. When LED 105-1 is lit, the voltage applied across LED 105-1 is about 3.0V, and is not sufficient to turn on diode 110-2. As a result, diode 110-2 is off and operates as an open circuit. The current path for current I3 is therefore open. Current I1 flows as current I2. Similarly, the voltage dropped across LED 105-2 is not sufficient to turn on diode 110-4. As a result, diode 110-4 is off and operates as an open circuit. The current path for current I5 is therefore open and current I2 flows as current I4. Effectively, current I1 flows through both LEDs 105-1 and 105-2 as respective currents I2 and I4. Consequently, both LEDs 105-1 and 105-2 are lit.

For illustration of a different operational state, the conditions present when LED 105-1 does not function while LED 105-2 functions normally will be described. If LED 105-1 does not function, but operates as a short circuit, current I1 flows as current I2 and current I4 through LED 105-2. LED 105-2 continues to operate. Effectively, the rest of the LEDs 105 in the LED chain continue to be lit.

If LED 105-1 does not function, but operates as an open circuit, current I1 flows as current I3. Both Zener diodes 110-1 and 110-2 are forward biased because voltage V1 is sufficient to light the chain of LEDs 105 is sufficient to forward bias LED 110-1. Voltage V1' is also larger than the breakdown voltage, or the Zener voltage, of Zener diode 110-2. As a result, Zener diode 110-2 operates to allow current I3 to flow through Zener diode 110-2. In other words, current I3 flows through both diodes 110-1 and 110-2. Current I3 then continues to flow as current I4 to light LED 105-2 and the rest of the LEDs in the chain of LEDs 105 (not shown).

#### Exemplary Circuit—Further Embodiments

FIG. 4 is a diagram of an LED circuit 400 and FIG. 5 is a cross section diagram of a semiconductor structure represented by the LED circuit 400, in accordance with some embodiments.

5

Compared with circuit 100, circuit 400 does not include Zener diodes 110-1 and 110-3. In other words, each LED 105 is coupled to one Zener diode 110. For illustration, LED 105-1 is coupled to Zener diode 110-2 while LED 105-2 is coupled to Zener diode 110-4. Consequently, in some embodiments, N+ regions 410-1 and 410-3 replace P+ regions 210-1 and 210-3 in FIG. 1, respectively. Zener diode 110-2 is formed by P+ region 210-2, N region 218-1, and N+ region 410-1. Similarly, Zener diode 110-4 is formed by P+ region 210-4, N region 218-2, and N+ region 410-3.

The N side of Zener diode 110-2 is coupled to the P side of LED 105-1 through node 115. Correspondingly, N region 218-1, N+ region 410-1, connecting metal 215-1, bond pad 220-1, and P portion 2055-1 of LED layer 205-1 are electrically coupled together. Similarly, the N side of Zener diode 110-4 is coupled to node 122, the P side of LED 105-2, node 120, and the N side of LED 105-1. Correspondingly, N region 218-1, N+ region 410-3, connecting metal 215-4, bond pad 220-2, P portion 2055-3 of LED layer 205-2, connecting metal 215-3, P+ region 210-2, connecting metal 215-2, connecting metal 225-1 and N portion of LED layer 205-1 are coupled together.

Functionally, circuit 400 operates in the same manner like circuit 100 in which Zener diodes 110-1 and 110-3 in circuit 100 are in the forward-bias mode. In such a situation, Zener diodes 110-1 and 110-3 operate as short circuits.

In various embodiments, the chain of LEDs 105 is formed in an array configuration. The last LED on a row is coupled to the first LED on the next row. For illustration, a chain of LEDs includes 9 LEDs 105-1 to 105-9. The array has 3 rows and 3 columns. The first row includes LEDs 105-1, 105-2, and 105-3. The second row includes LEDs 105-4, 105-5, and 105-6, and the third row includes LEDs 105-7, 105-8, and 105-9. LED 105-3 on the first row is coupled to LED 105-4 on the second row. LED 105-6 on the second row is coupled to LED 105-7 on the third row. The chain of Zener diodes is configured accordingly to reflect either one of the embodiments of FIG. 1 or FIG. 4. The different numbers of LEDs in the chain, in a row, and/or in a column are within the scope of various embodiments. Zener diodes 110 also protect the P-N junctions in the array structure.

#### Exemplary Fabrication Steps

FIGS. 6A to 6K are cross section views of structures 600A to 600K used to illustrate the fabrication steps of circuit 100, in accordance with some embodiments.

In FIG. 6A, initially a photo resist layer 850A with an opening 855A is deposited on top of substrate 230. Implantation is then performed through opening 855A on substrate 230. N well 218-1 is thus formed, resulting in structure 600A. After the N-well implantation step, photo resist layer 850A is removed.

In FIG. 6B, a photo resist layer 850B is deposited on top of structure 600A with photo resist layer 850A having been removed. Photo resist layer 850B includes openings 855B-1 and 855B-2. Implantation is then performed on N-well 218-1 through openings 855B-1 and 855B-2 to form P+ regions 210-1 and 210-2, respectively. As a result, structure 600B is formed. In the case N+ region 410-1 replaces P+ region 210-1, P+ region 210-2 is formed first in some embodiments, then the N+ material is implanted to form N+ region 410-1. In various embodiments, after P+ region 210-2 is formed, a photo resist layer is deposited to cover P+ region 201-2 while the N+ material is implanted. After structure 600B is formed, photo resist layer 850B is removed.

6

In FIG. 6C, dielectric layer 240 is deposited on top of structured 600B with photo resist layer 850B having been removed. In some embodiments, layer 240 is about 5000 Å. Etching is performed through layer 240 to form openings 855C-1 and 855C-2 that expose P+ regions 210-1 and 210-2, respectively. Structure 600C is formed.

In FIG. 6D, layers 860D-1 and 860D-2 are formed on top of P+ regions 210-1 and 210-2, respectively. Seed layer 865D is then deposited, resulting in structure 600D. In some embodiments, layers 860D-1 and 860D-2 include titanium silicon (Ti—Si) and are used to form the contacts. For example, layer 860D-1 serves as means to electrically couple P+ region 210-1 to bond pad 220-1. Similarly, layer 860D-2 serves as means to electrically couple P+ region 210-2 to bond pad 220-2. Effectively, layers 860D-1 and 860D-2 correspond to connecting metals 215-1 and 215-3 in FIG. 2, respectively. Layer 865D includes titanium copper (Ti—Cu), and serves as a seed layer for layer 862E shown in FIG. 6E.

In FIG. 6E, layer 862E is formed on top of structure 600D. Photo resist layer 850E, then layers 864E-1 and 864E-2 are formed on top of layer 862E. Structure 600E is therefore formed. In some embodiments, layer 862E is electroplated with copper (Cu) on top of layer 865D. Effectively, layer 865D is merged into layer 862E. Layer 862E is later separated to form bond pads 220-1 and 220-2. Layer 850E defines the boundary for layers 864E-1 and 864E-2. Layer 864E-1 serves to bond LED layer 205-1 to bond pad 220-1 via portion 2055-1. Similarly, layer 864E-2 serves to bond LED layer 205-2 to bond pad 220-2 via portion 2055-3. Layers 864E-1 and 864E-2 are not shown in FIG. 2. In some embodiments, layers 864E-1 and 864E-2 are electroplated with nickel gold (Ni—Au), silver (Ag), or gold (Au). Other bonding and electrical connection materials and bonding techniques, however, are within the scope of various embodiments. Some exemplary bonding techniques include eutectic bonding, adhesive bonding, fusion/direct bonding, etc. After layers 864E-1 and 864E-2 are formed, photo resist layer 850E is removed.

In FIG. 6F, layer 862E is separated to form bond pads 220-1 and 220-2. First, photo resist layer 850F having an opening is formed on top of structure 600E with photo resist layer 850E having been removed. A wet etch process is performed to separate layer 862E into two separate sections corresponding to bond pads 220-1 and 220-2. After the bond pads 220-1 and 220-2 are formed, photo resist layer 850F is removed.

In FIG. 6G, LED layers 205-1 and 205-2 are built on respective layers 864E-1 and 864E-2. Connecting metal 225-1 is formed on top of LED layer 205-1. As a result, structure 600G is formed. In various embodiments, LED layers 205-1 and 205-2 are bonded to respective layers 864E-1 and 864E-2 with high precision alignment. For example, in some embodiments, the bonding shift provided by the bonding tool is within 5 μm to prevent the impact of the downstream lithography process that could degrade device performance and reliabilities caused by leakage.

In FIG. 6H, dielectric layer 810H is formed on top of structure 600G, resulting in structure 600H. In some embodiments, dielectric layer 810H is of the same material as dielectric layer 240. Consequently, layer 810H and 240 are considered as one dielectric layer. Dielectric layer 810H and 240 being of different materials are within the scope of various embodiments.

In FIG. 6I, unwanted portions of layer 810H are removed. For illustration, portion 810HK of layer 810H is kept while portions 810HR-1 and 810HR-2 are removed. In some embodiments, a photo resist layer 850I is deposited to cover

7

portion **810HK**. Portions **810HR-1** and **810R-2** are then removed, resulting in structure **600I**.

In FIG. **6J**, connecting metal **215-2** is formed. In some embodiments, photo resist layers **850J-1** and **850J-2** are formed to define the boundary for layer **215-2** before layer **215-2** is deposited on top of structure **600I**. For example, photo resist layer **850J-1** sets the boundary so that layer **215-2** covers a portion of connecting metal **225-1**. Similarly, photo resist layer **850J-2** sets the boundary so that connecting metal **215-2** covers a portion of layer **864E-2** and is separated from LED layer **205-2**.

After connecting metal **215-2** is formed, photo resist layers **850J-1** and **850J-2** are removed, resulting in structure **600K** shown in FIG. **6K**.

In various embodiments, the chain of LEDs **105** with the corresponding Zener diodes are formed in the same die, which is advantageous over other approaches where the LEDs and the protection diodes are built individually and later integrated in a printed circuit board.

A number of embodiments have been described. It will nevertheless be understood that various modifications may be made without departing from the spirit and scope of the disclosure. For example, the steps in FIGS. **6A-6K** are used for illustration. In various embodiments, a chain of LEDs **105** is formed in parallel. As a result, forming LEDs **105** in the chain is done in parallel with and/or in a similar manner as forming LED **105-1** as illustratively shown in FIGS. **6A-6K**. Similarly, forming corresponding Zener diodes **110** and related connections is done in parallel with and/or in a similar manner as forming Zener diodes **105-2** and **105-3** and corresponding connections as explained with reference to FIGS. **6A-6K**. Various figures show a particular dopant concentration, but different dopant concentrations are within the scope of various embodiments. For example, each of the P+ regions **210-1**, **210-2**, **210-3**, and **210-4** may be replaced by a P or P- dopant concentration. Similarly, each of the N regions **218-1** and **218-2** may be replaced by an N- or N+ dopant concentration. Each of the N+ regions **410-1** and **410-3** may be replaced by an N or N- dopant concentration, etc.

Some embodiments regard an LED structure that comprises a first dopant region, a dielectric layer on top of the first dopant region, a bond pad layer on top of a first portion of the dielectric layer, and an LED layer having a first LED region and a second LED region. The bond pad layer is electrically connected to the first dopant region. The first LED region is electrically connected to the second bond pad layer.

Some embodiments regard an LED structure that comprises a well region, a first dopant region, a second dopant region, a dielectric layer, a first bond pad layer, a second bond pad layer, a first LED layer, and electrical coupling means. The dielectric layer is on top of the first dopant region, the second dopant region, and the well region. The first bond pad layer is separated from the second bond pad layer and is electrically connected to the first dopant region. The second bond pad layer is electrically connected to the second dopant region. The first LED layer has a first LED region and a second LED region. The first LED region is electrically connected to the first bond pad layer. The electrically coupling means couples the second LED region and the second bond pad layer.

Some embodiments regard a light emitting diode (LED) structure comprising a first well region, a second well region, a dielectric layer, a first bond pad layer, a second bond pad layer, a first LED layer, and a second LED layer. The first well region has a first dopant region and a second dopant region. The second well region has a third dopant region and a fourth dopant region. The dielectric layer is on top of the first well

8

region and the second well region. The first bond pad layer and a second bond pad layer are on top of the dielectric layer and are electrically separated. The first LED layer has a first LED portion and a second LED portion. The second LED layer has a third LED portion and a third LED portion. The first bond pad layer is electrically connected with the first dopant region and with the first LED portion. The second LED region is electrically connected with the second bond pad layer, the second dopant region, the third dopant region, and the third LED region. The fourth LED region is electrically connected with the fourth dopant region.

Some embodiments regard a method. In the method, a well is formed in a substrate. A first implant region and a second implant region are formed in the well, resulting in a first structure. A first dielectric layer is formed over the first structure, leaving a first opening to expose at least a first portion of the first implant region and a second opening to expose at least a second portion of the second implant region, resulting in a second structure. A first bond pad layer and a second bond pad layer are formed over the second structure, resulting in a third structure. The first bond pad layer and the second bond pad layer are electrically separated. The first bond pad layer is electrically connected with the first implant region. The second bond pad layer is electrically connected with the second implant region. A first LED layer is electrically connected with the first bond pad layer, resulting in a fourth structure. The LED layer has a first LED portion and a second LED portion. The first LED portion is electrically connected with the first bond pad layer. A second dielectric layer is formed over the fourth structure, resulting in a fifth structure. A connecting layer is formed over the fifth structure. The connecting layer electrically couples the second LED portion with the second bond pad layer.

The above methods show exemplary steps, but they are not necessarily performed in the order shown. Steps may be added, replaced, changed order, and/or eliminated as appropriate, in accordance with the spirit and scope of disclosed embodiments. For example, the following are variations with respect to forming layers **864E-1** and **864E-2** in FIGS. **6D** and **6E**. In some embodiments, layer **850E** is formed on top of structure **600D** and thus on top of layer **865D**. Layer **862E** is formed, and layer **850E** and **865D** are removed. Layers **864E-1** and **864E-2** are then formed. Alternatively, after layers **850E** and **862E** are formed, layers **864E-1** and **864E-2** are formed. Layers **850E** and **865D** are then removed.

What is claimed is:

1. A structure, comprising:

a first zener diode that contains a first doped region and a second doped region that is disposed in the first doped region, wherein the first and second doped regions have different types of conductivity;

a second zener diode electrically coupled in series with the first zener diode, wherein the second zener diode shares the first doped region with the first zener diode and further contains a third doped region that is disposed in the first doped region, and wherein the first and third doped regions have different types of conductivity; and a light-emitting diode (LED), wherein the first and second zener diodes collectively are electrically coupled to the LED in parallel.

2. The structure of claim 1, wherein the second doped region and the third doped region are each substantially more heavily doped than the first doped region.

3. The structure of claim 2, wherein the first doped region includes an N-well, and wherein the second and third doped regions each include a heavily-doped P-well.

9

4. The structure of claim 1, further comprising a patterned electrically-insulating layer disposed over a portion of the first and second zener diodes, and wherein the LED is disposed over the patterned electrically-insulating layer.

5. The structure of claim 4, wherein the patterned electrically-insulating layer includes a first opening partially exposing the second doped region and a second opening partially exposing the third doped region;

and wherein the structure further comprises:

a first conductive element disposed in the first opening; and  
a second conductive element disposed in the second opening.

6. The structure of claim 5, further comprising:

a first bond pad disposed over, and electrically coupled to, the first conductive element; and  
a second bond pad disposed over, and electrically coupled to, the second conductive element.

7. The structure of claim 6, further comprising a connecting metal disposed over the first and second bond pads and over the LED.

8. The structure of claim 7, wherein:

the LED includes a first doped layer and a second doped layer, the first and second doped layers having different types of conductivity;

the first doped layer of the LED is electrically coupled to the second doped region of the first zener diode through the first bond pad and the first conductive element; and  
the second doped layer of the LED is electrically coupled to the third doped region of the second zener diode through the connecting metal, the second bond pad, and the second conductive element.

9. The structure of claim 1, wherein the LED is a first LED, and further comprising:

a third zener diode that contains a fourth doped region and a fifth doped region that is disposed in the fourth doped region, wherein the fourth and fifth doped regions have different types of conductivity;

a fourth zener diode electrically coupled in series with the third zener diode, wherein the fourth zener diode shares the fourth doped region with the third zener diode and further contains a sixth doped region that is disposed in the fourth doped region, and wherein the fourth and sixth doped regions have different types of conductivity; and  
a second light-emitting diode (LED), wherein the third and fourth zener diodes collectively are electrically coupled to the second LED in parallel.

10. The structure of claim 1, wherein the first LED is electrically coupled in series with the second LED.

11. A structure, comprising:

a first zener diode that contains a first doped region and a second doped region that is disposed in the first doped region, wherein the first and second doped regions have different types of conductivity, and wherein the second doped region is more heavily doped than the first doped region;

a second zener diode electrically coupled in series with the first zener diode, wherein the second zener diode shares the first doped region with the first zener diode and further contains a third doped region that is disposed in the first doped region, and wherein the first and third doped regions have different types of conductivity, and wherein the third doped region is more heavily doped than the first doped region; and

a light-emitting diode (LED) disposed over the first and second zener diodes;

wherein:

10

the LED includes a first doped layer and a second doped layer, the first and second doped layers having different types of conductivity;

the first doped layer of the LED is electrically coupled to the second doped region of the first zener diode; and  
the second doped layer of the LED is electrically coupled to the third doped region of the second zener diode.

12. The structure of claim 11, further comprising a patterned dielectric layer disposed over a portion of the first and second zener diodes, and wherein the LED is disposed over the dielectric layer.

13. The structure of claim 12, further comprising:

a first conductive element disposed in a first opening of the patterned dielectric layer; and  
a second conductive element disposed in a second opening of the patterned dielectric layer;  
a conductive pad disposed over, and electrically coupled to, the first conductive element; and  
a second conductive pad disposed over, and electrically coupled to, the second conductive element.

14. The structure of claim 13, further comprising:

an insulating component that electrically isolates the first conductive pad from the second conductive pad; and  
a connecting metal disposed over the insulating component, wherein a first distal end of the connecting metal is electrically coupled to the LED, and a second distal end opposite the first distal end of the connecting metal is electrically coupled to the second conductive pad.

15. The structure of claim 11, wherein the LED is a first LED, and further comprising:

a third zener diode that contains a fourth doped region and a fifth doped region that is disposed in the fourth doped region, wherein the fourth and fifth doped regions have different types of conductivity;

a fourth zener diode electrically coupled in series with the third zener diode, wherein the fourth zener diode shares the fourth doped region with the third zener diode and further contains a sixth doped region that is disposed in the fourth doped region, and wherein the fourth and sixth doped regions have different types of conductivity; and  
a second light-emitting diode (LED), wherein the third and fourth zener diodes collectively are electrically coupled to the second LED in parallel, and wherein the second LED is electrically coupled in series with the first LED.

16. A structure, comprising:

a doped well disposed in a substrate, the doped well having a first type of conductivity;

a first heavily doped region and a second heavily doped region disposed in the doped well, the first and second heavily doped regions each having a second type of conductivity different from the first type, wherein the first and second heavily doped regions are separated by a portion of the doped well, and wherein the doped well and the first heavily doped region collectively constitute a first zener diode, and wherein the doped well and the second heavily doped region collectively constitute a second zener diode;

a patterned dielectric layer disposed over the doped well, wherein the patterned dielectric layer includes a first opening disposed over the first doped region and a second opening disposed over the second doped region; contact elements disposed over the first and second heavily doped regions and within the first and second openings;  
a first bond pad disposed over the first heavily doped region and a second bond pad disposed over the second heavily doped region; and

a first light-emitting diode (LED) disposed over the first bond pad and a second LED disposed over the second bond pad, the first and second LEDs each including a light-emitting layer disposed between a first doped semiconductor layer and a second doped semiconductor layer, the first and second doped semiconductor layers having different types of conductivity. 5

**17.** The structure of claim **16**, further comprising: a first conductive element disposed over the first LED and a second conductive element disposed over the second LED. 10

**18.** The structure of claim **17**, further comprising: a further patterned dielectric layer disposed over the first and second LEDs and over sidewalls of the first and second bond pads, the further patterned dielectric layer exposing the first and second conductive elements. 15

**19.** The structure of claim **18**, further comprising: a connecting metal layer disposed over the further patterned dielectric layer, wherein the connecting metal layer electrically interconnects the first and second LEDs.

**20.** The structure of claim **19**, wherein the first doped semiconductor layer of the first LED is electrically coupled to the second doped semiconductor layer of the second LED. 20

\* \* \* \* \*